

SOUTH PRODUCTION NOTES

December 10, 2014
11-7 Shift

BASF EMPLOYEES
48 Last Recordable
528 Last Lost Time

Be sure to check weigh all bags off of the calciners and fill out the log sheet downstairs by the scale and Attach "Packaged By" label with your initials.

#1 MED / AL 4126 1/16th:

Running Al 4126 1/16" size. Do not get any more than 10 bags ahead on the floor.

Midnight shift:.

Day shift: Hold...10 bags on floor. Will start feeding calciner if it stays lit.

Cannot start MED line until DL Page re-connects F1 piping above #2 P&S spiral (pipe had to be removed to work on spiral top).

Afternoon shift: Did not run. Calciner will not stay lit.

#1 RC /AL 4126 1/16th:

Will not stay lit. Need to switch over to 1/16"

Midnight Shift:

Day shift: Calciner was relit and if temps hold, will start feeding just after noon today. IMC noticed the combustion blower filter was very dirty and after cleaning it, the calciner stayed lit. If the calciner kicks out for any reason, do not attempt to relight. Call Kirk or Mike Baron immediately and advise if any error signals.

Afternoon shift: Calciner kicked out at 2:20 and Mike Barron and Kirk were notified. IMC worked on a combustion blower wire. Later, the calciner kicked out again.

Exhaust to Trimer

#2 MED line / Cu-0860:

Hold -Spiral elevator is still down. **Be sure to use wet mix on every batch.**

Midnight shift: hold

Day Shift: DL Page repositioning section of F1 today to access spiral top.

Afternoon Shift: Hold. Waiting for repairs.

#2 RC/ Cu 0860:

Bladder on bag off station should be working now. Still need to feed bags on 1st floor (Bodmann will advise)

Midnight shift: awaiting Feed

Day Shift: Awaiting feed

Afternoon Shift: Waiting.

Exhaust to

#3 MED/ D-1708:

Running. Add wet mix to each batch... 1/2 – 1 of a drum each batch. When we are out of zeolite, we need to do 3-4 drum batches of wet mix and mix without water for 10-15 minutes. Then we can add water in 10# increments until we get a mix that will extrude.

Midnight shift:

Day Shift: Continuing batches and add 1/2 drum wet mix. When we are out of raws for D 1708 (probably zeolite), we will then work on 3-4 drum batches of wet mix only directly in to the mixer.

Afternoon Shift: Continued. Will run out of zeolite early on midnight. Then we will need to do 3-4 drum batches of wet mix and mix without water for 10-15 minutes. Then we can add water in 10# increments until we get a mix that will extrude.

#3 RC / D-1708:

Continue. Call out maintenance if repairs are needed. Monitor fines and advise John. Need to close fines drums and place in Red zone, write the weight on the board in control room and include on SAP Sheets. change out the fines screen to .084 x 1/4 Feed "hold for Bodmann" bags.

Midnight shift:

Day shift: Having trouble keeping lit, feed was stopped earlier in shift after restarting due to excessive fines in fines drum (this may have been due to bad material when MED started back up). Also, we are waiting for DL Page to finish replacing section of F1 above #2 P&S spiral...cannot start feeding #3 calcier until this work is done (F1 suction line on ammonia tote) and after calciner lit and holding temp. Should be OK to restart feed on afternoons if all the above are ready.

Afternoon Shift: Controller looked at by electricians and ok to start the feed. Walk through being performed late in the shift.

Exhaust to CTO

#4 RC / 5202:

Finished. Clean up sheet in the Group Leader's office.

Midnight shift:

Day Shift: Use clay for flushing the calciner, should be in Tuesday but work needed on calcier discharge spout (DL Page needs to weld cracks in spout). Will look at feeding clay (5202) flush through on Wednesday, then fire up calciner.

Afternoon Shift: No change.

Exhaust to Trimer

#5 RC / Cu-3818:

Make sure to get your surface areas! Need material from DC analyzed

New material in rail sheds and behind 4/5

Midnight Shift:

Day shift: Continue...lab is checking material collected in 5B DC to see if OK for 3818 use

Afternoon shift: More refire bags were found and staged. Two bags of fresh material were fed before more refires were found.

Exhaust to 5A DC

#6 RC & Dryer / D-0756

Use Auto Sampler for bags. 32 oz and a 16 oz grab for every bag. Be Sure to Check Weigh all bags and fill out sheet by Scale.

Midnight shift:

Day Shift: Continue. Zone 1 temps are a bit low (work order submitted for electrician to look at Zone 1, running too low).

Afternoon shift: Zone one corrected, then feed started and ran most of the shift until the dryer kicked out late in the shift. Electricians working on relighting.

Exhaust to Sly Scrubber

6 Tank /D-5253 empty

Continue. Drain looked at by Schirmer and Lucas- not fixed yet

Midnight Shift:

Day Shift: No activity

Afternoon shift: No change.

New Pfaudler / D 5253 done

Butterfly valve was replaced on the pfaudler by maintenance.

Midnight shift:

Day shift: No activity, will need to continue clean-up and report to Steve Niewiamdomski when pfaudler is ready.

Afternoon Shift: No change.

7 Tank AMT, KLP solution next?

Tank was being rinsed over weekend. Tank will not be needed until late December...will try to get cleaning instructions soon. Tank has a lot of residue on bottom...needs cleaned

Midnight Shift:

Day Shift: Currently circulating (is it just water or water/acid?).
Afternoon shift: It is just water.

Old Pfaudler / D-0756:

Running. Continue to run to keep up with #6 Dryer/Calciner PLEASE RECORD THE DRAINAGE WEIGHT AND GET A DRAINAGE SAMPLE FOR EACH BATCH!!!
Midnight Shift:
Day Shift: Continue 2nd half off shift
Afternoon shift: Continued. Batch made.

National Dryer: D-5253

Cleaning- Schirmer to bead blasting belt tuesday
Midnight Shift:
Day shift: Schirmer started cleaning dryer belt
Afternoon Shift:

PK Blender/AI-3915:

New Screener is running. Be sure to only screen 1 batch ahead of what you are making in the PK. We cannot let the screened sterotex/graphite sit. It causes havoc on the Horne machines.
Midnight Shift: NA
Day shift: No activity, will look to make batches afternoon shift
Afternoon shift: Training done. Batch made, then wild goose chase for some 112 bags ensued. 6 bags ahead of the Horne machines.

Abbe Blender / 5206 Done

Done for a while. Area Cleaned and Contractors finished with Sprinkler work
Midnight shift: NA
Day shift: NA
Afternoon shift: NA

Tower 3/ Cu 0860:

Running.
Midnight Shift:
Day shift: Should be on hold (tote line space needed)
Afternoon shift: Should be able to unload early on midnight shift.

Tower 6 / Cu 0860:

Running

Midnight Shift:

Day shift: Dropping bottom, sheave change today

Afternoon shift: Washed down and on hold for maintenance tomorrow.

North Screener / Cu-0860:

Change to Cu-0860. Keep running

Midnight shift:

Day shift: Continue

Afternoon shift: Continued.

South Screener / Cu-0860:

Change to Cu-0860. Keep running

Midnight shift:

Day shift: Continue

Afternoon Shift: Continued.

#2662 (west) Pill Machine / Al-3915 T 5/32:

Running, when able.

Midnight shift:

Day Shift: Speed control repaired, running

Afternoon shift: Ran pretty well.

#2664 (east) Pill Machine / Al-3915 T 5/32:

Running, when able.

Midnight shift:

Day Shift: Kind of running, still some powder flow issues

Afternoon shift: Ran pretty well.

TK #2 / V 2046:

Running 2046

Midnight shift:

Day Shift: Continue, but do not load another bag until sagger feeder is worked on (no more dropping bags into hopper and scooping). Work order submitted to fix the sagger feeder screw – it is jammed.

Afternoon shift: Bag that was hanging was emptied. No other bag is to be loaded until the automatic feeder is fixed.

TK #4 / Cu 0203, Cu 0540 next:

Need to switch to 0540 saggars
Midnight shift: down
Day Shift: down
Afternoon shift:

Harrop Kiln / AI 3920:

AI 3920 - 90 min Cart- operator must keep area cleaned
Midnight shift:
Day Shift: Continue
Afternoon shift: Continued.

Building 27 Belt Filter / Cu 6081:

Hold for the weekend– Please fill bags to 1200# and ensure bags are clean of powder on the outside of them and the pallets as they have to be transported down the street.

Midnight shift:
Day shift: Down day shift, restart afternoon
Afternoon Shift: Down.

Priorities:

- 1) #3 MED/#3RC/CTO - Finish D-1708 - Must get in wet mix - Clean up next week will have to be quick to salvage line time
- 2) West Pfaudler/National Dryer/#4RC/Trimer - Finish calcining D5253 then clean for D5202 next while pfaudler is idle (Art please confirm Monday). Finishing the D5253 is the rush, not the changeover
- 3) Reduction Towers - Cu-0860 drop Tower 6 bottom Monday for Pd 1930, sheave change
- 4) Reduction Tower Screeners - keep Cu-0860 screening moving
- 5) #1 Line/#1RC - Finish AI -4126 E 1/8 - them move on to AI-4126 E 1/16.....Will have to decide if we do Chevron or not. I will sort it out next week with Art. I have discussed with Tim C
- 6) #2 Tunnel Kiln - V 2046 P - watch temps close, keep loading high
- 7) East Pfaudler/HC-11 Dryer/#6 RC - ships mid December, we need to stay on rate
- 8) #5 RC - run into next weekend 12/13 then switch
- 9) Harrop Kiln - plenty of base to fire
- 10) Horne Tableting / PK as needed - need to ramp up on Pill mix as Selectsorb is on the horizon
- 11) Tunnel Kiln Area - Touch up paint on Cu-0860 ERL green drums - ships 12/15 and we have about half of ~550 drums to fix
- 12) South Precip - North hand to mouth on feed....

Maintenance & Other

- 1) #2 Line will be down until Monday at least for spiral repairs - #2RC - test out new syntron controls while line is down
- 2) Acid wash new pfaudler for repairs week of December 15
- 3) Vacuum national drier best as possible to soda blast next week
- 4) Drop tower 6 bottom and sheave change Monday December 8.
- 5) Need to clean and acid wash T4 and T-6 in Building 27 for checks. timing TBD based on how much 6081 we need to finish and when. Val also needs a week for punchlist items

Shipments to finish for December

- 1) D5253 - wraps up this weekend, analyze and ship ASAP
- 2) D-0756 - finishes mid December - need a plan to ship without final metals analysis (TDR with ART?)
- 3) V-2046 - told Tim C we would target a min of 25K week of Dec 22 with the last week of the month as a fallback, which I would like to avoid.
- 4) Cu-0860 drum fix